

Work Order ID 143712-2

March 21, 2016 3:36:44 PM

143712

Page 1

Item ID: D3769-3

Accept

N9000040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Tube

Start Date: 3/28/2016

Start Qty: 10.00

10

20

Cust Item ID:

Required Date: 4/8/2016

Req'd Qty: 10.00

10

20

Customer:

Reference:

Approvals:

Process Plan: SUDate: 20160321

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3769

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.03

Small Fab

1-cut tube to length as per dwg D3769

2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig

3- deburr

19

FF

MAY 02 2016

110

0.00

110

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

19

DAS
38

MAY 09 2016

120

0.00

120

HandFinish

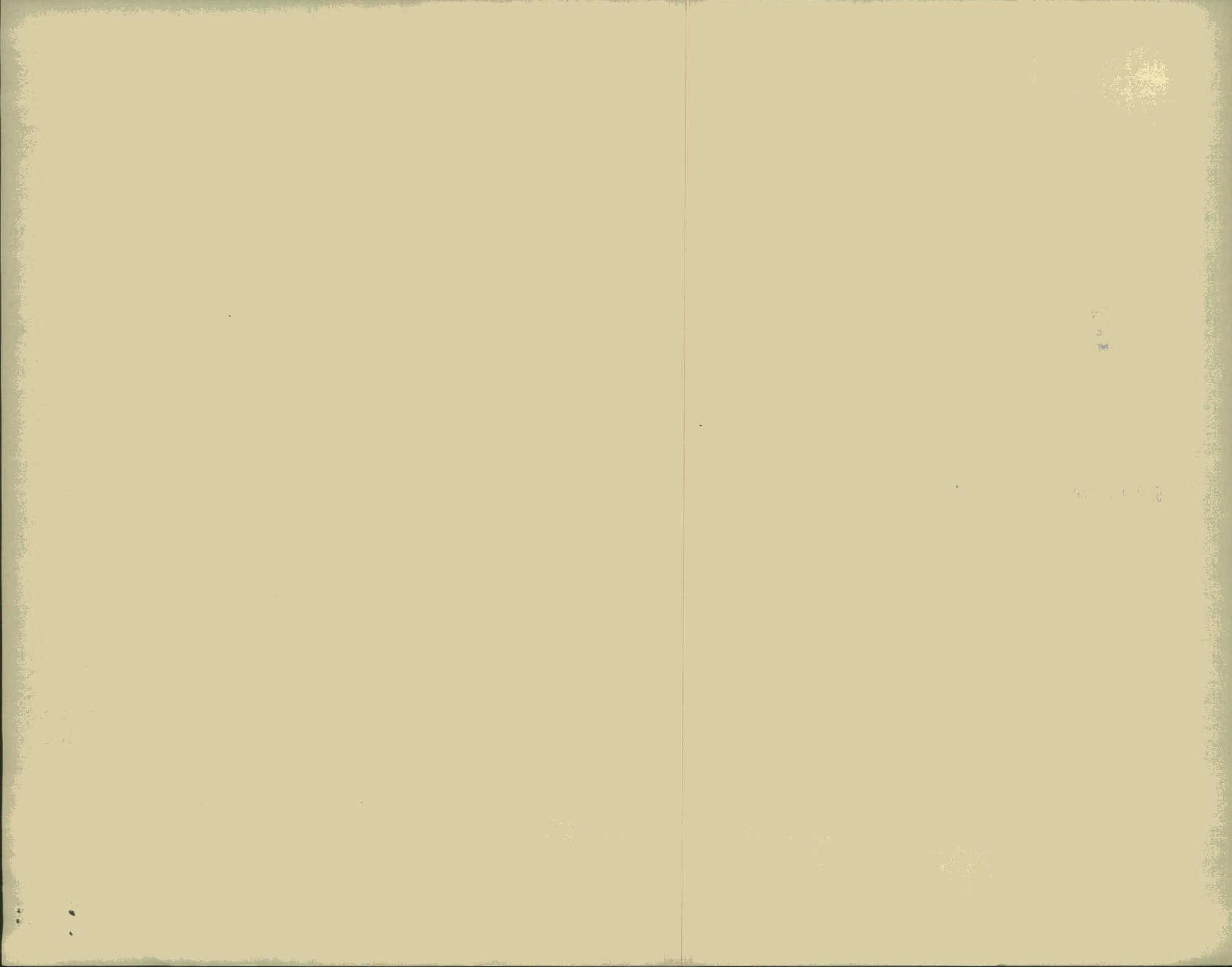
Chemical Conversion Coat per QSI005 4.1

Memo

0.02

Hand Finishing

191 d 11 16/05/21



Work Order ID 143712

March 21, 2016 3:36:44 PM

143712

Page 2

Item ID: D3769-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube
 Start Date: 3/28/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				(19)			DAS 38 9-89 MAY 04 2016
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>S1254</u> Memo	0.00 0.00				19			MAY 04 2016 DAS 8 9-89
150 *150* QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 0.02							16/5/9 JF MAY 05 2016

MAY 05 2016



Picklist Print

March 21, 2016 3:36:49 PM

Page 1

Work Order ID: 143712

143712

Parent Item: D3769-3

D3769-3

Parent Item Name: Tube

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased			No	100	f	94.1894	1.265	13.31579		MAY 02 2016	

M6061T6T1 000W065

6061T6 RD TUBE 1.00 x .065w

**

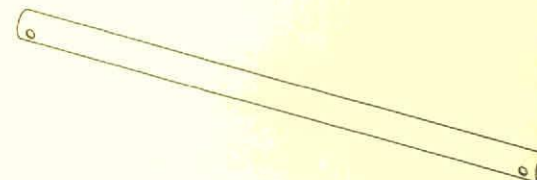
FF

Location	Loc Qty	Loc Code
GA002	65.571927	
M126183	0.17416	
M132597	3.844877	
M133700	13.55289	
M134504	48	
MAT	28.617432	
M132577	28.617432	

$$\begin{array}{r}
 2.663150 \\
 10.652632 \\
 9.321053 \\
 \hline
 2.663150 + 2.663150 = 13.31579
 \end{array}$$

 NOT Pulled



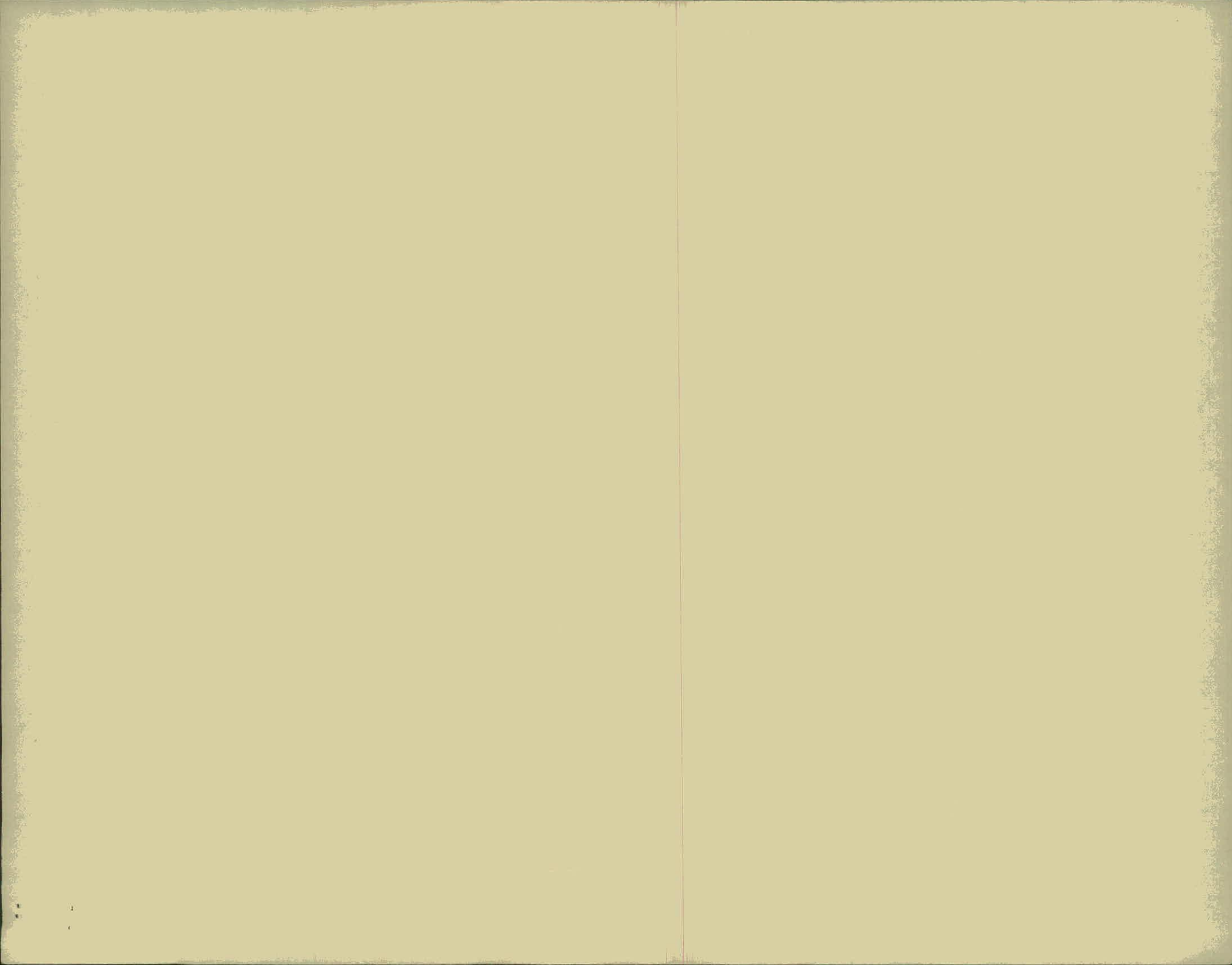


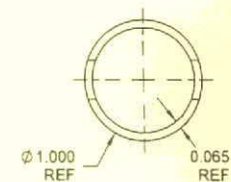
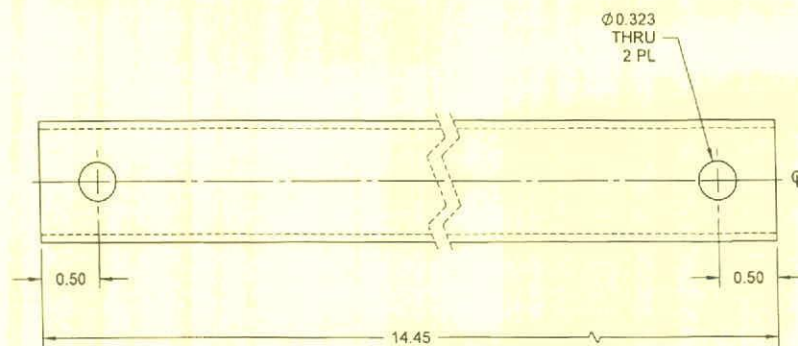
D3769-5 TUBE

RELEASED
08-06-17

A	NEW ISSUE		HS	08.06.04
REV.		DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3769 TITLE TUBE		
DRAWN	HS			
CHECKED	<i>[Signature]</i>			REV.
MFG. APPR.	<i>[Signature]</i>			SHEET 1 OF
APPROVED	<i>[Signature]</i>			SCALE
DE APPR.	<i>[Signature]</i>			NT
DATE	08.06.04	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		

COPYRIGHT © 2008 BY DART AEROSPACE LTD
 THE DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT
 NOT TO BE USED FOR ANY PURPOSE (OR COPIED OR COMMUNICATED) TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

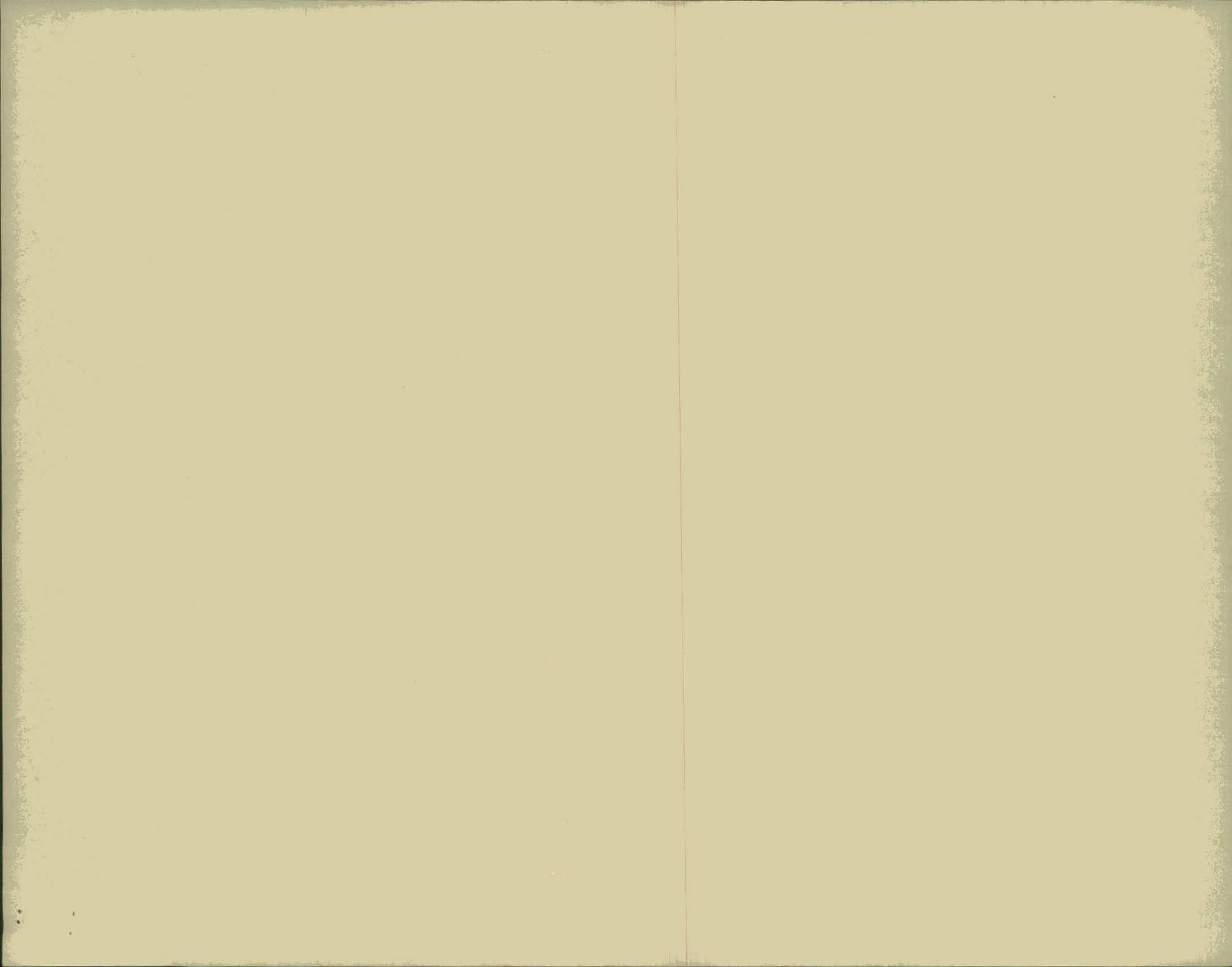


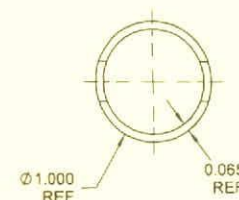
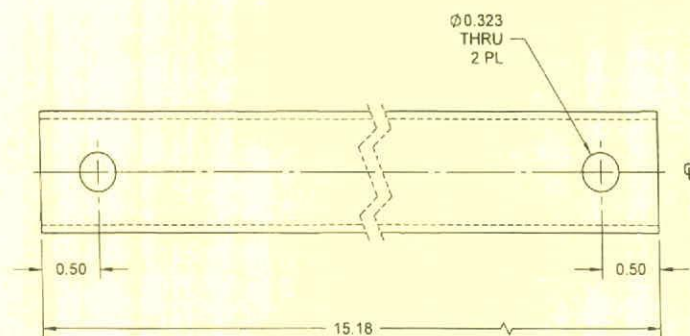


D3769-1 TUBE

RELEASED
08-06-04

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3769	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

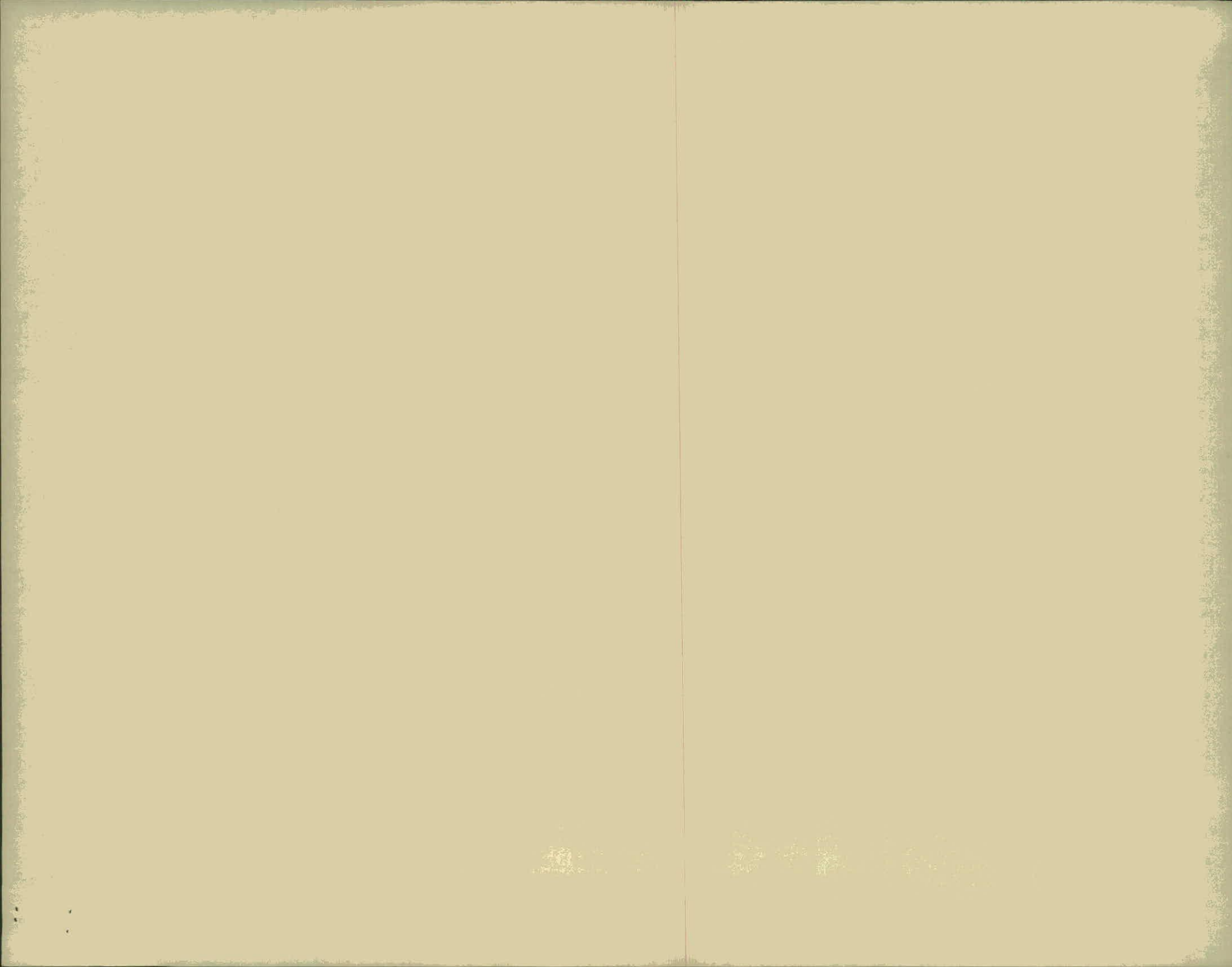


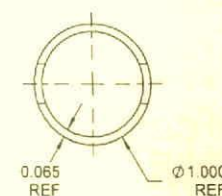
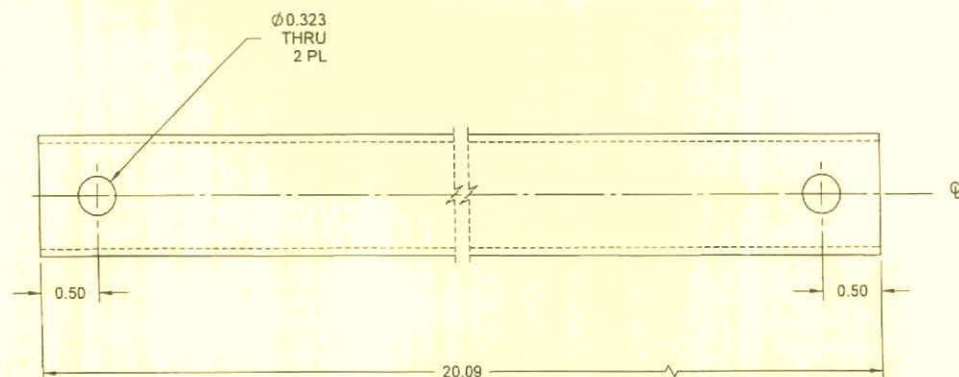


D3769-3 TUBE

RELEASED
09-06-14/14

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3769	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	TUBE	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





D3769-5 TUBE

RELEASED
Handwritten signature and date: A. D. 16/1/04

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG APPR	<i>[Signature]</i>	D3769	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



